

LNP™ THERMOCOMP™ FX93387L compound

Polyethylene
SABIC Innovative Plastics

Message:

LNP* THERMOCOMP* FX93387L is a compound based on Polyethylene resin containing proprietary filler(s). Added feature of this grade is: Low Extractable.
Also known as: LNP* THERMOCOMP* Compound PDX-F-93387 LE
Product reorder name: FX93387L

General Information			
Filler / Reinforcement	Proprietary		
Features	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	0.988	g/cm ³	
--	0.983	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	2.4	%	
Across Flow : 24 hr	2.4	%	
Water Absorption			
24 hr, 50% RH	0.010	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1340	MPa	ASTM D638
--	895	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	22.0	MPa	
Break	23.0	MPa	
Tensile Elongation			
Yield ²	9.3	%	ASTM D638
Yield	9.0	%	ISO 527-2/5
Break	15	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ³	866	MPa	ASTM D790
-- ⁴	863	MPa	ISO 178
Flexural Stress			
--	20.0	MPa	ISO 178
Yield, 50.0 mm Span ⁵	20.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	38	J/m	ASTM D256
23°C ⁶	4.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact (23°C)	940	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	74.0	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁷	73.0	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	46.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁸	44.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	193 to 204	°C	
Middle Temperature	210 to 221	°C	
Front Temperature	221 to 232	°C	
Processing (Melt) Temp	232	°C	
Mold Temperature	37.8 to 54.4	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	1.3 mm/min		
4.	2.0 mm/min		
5.	1.3 mm/min		
6.	80*10*4		
7.	80*10*4 mm		
8.	80*10*4 mm		

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